

Work Order ID 82390

82390

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March-30-12 7:47:23 AM

Item ID: D3393-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Battery Lock Assembly
 Start Date: 29/03/2012 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 12/04/2012 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/30 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3393 | Rev A | | | | | | | | |

| | | | | | | | | | |
|-----------------|--|------|--|--|--|----|---|---------|-------------|
| 100 | | 0.00 | | | | 5 | 0 | | FF 12-04-27 |
| *100* | Small Fab | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten | | | | | | | | |
| | | | | | | | | | |
| 110 | | 0.00 | | | | 5 | | 12-4-30 | |
| *110* | Large Fab | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | Tack Weld lock shaft to flat cam of a Max 1/8" Long QtyPart Number Description Batch A/RN/A SS Rod <u>M114509</u> | | | | | | | | |
| | | | | | | | | | |
| 120 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | 5x | 0 | | 12-04-30 |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 82390

82390

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March-30-12 7:47:23 AM

Item ID: D3393-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Battery Lock Assembly
 Start Date: 29/03/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 12/04/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/5/17
 11205-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

March-30-12 7:47:27 AM

Page 1

Work Order ID: 82390

82390

Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------------------------|--|-----------|----|--|--|-----|------|-----------|---|----|--|--|--|
| 5/16WC | | Purchased | No | | | 100 | Each | 1,766.000 | 2 | 10 | | | |
| *5/16WC* | | | | | | | | | | | | | |
| SS Flat Washer 5/16 FW516S1 | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| 115072 | | |
| ST377 | 1746 | |
| 120262 | 1746 | |
| ST522 | 20 | |
| 120208 | 20 | |

| | | | | | | | | | | | | | |
|------------------|--|-----------|----|--|--|-----|------|----------|---|----|--|--|--|
| 9567K21 | | Purchased | No | | | 100 | Each | 101.0000 | 2 | 10 | | | |
| *9567K21* | | | | | | | | | | | | | |
| Polyethelene Cap | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST380 | 101 | |
| 110822 | 1 | |
| 120743 | 100 | |

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D2728-7 | | Manufactured | No | | | 100 | Each | 0.0000 | 0 | 0 | | | |
| *D2728-7* | | | | | | | | | | | | | |
| Dart Logo label | | | | | | | | | | | | | |

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D3373-1 | | Manufactured | No | | | 100 | Each | 50.0000 | 1 | 5 | | | |
| *D3373-1* | | | | | | | | | | | | | |
| Cam Lock | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST039 | 50 | |
| 58463 | 2 | |
| 74862 | 19 | |
| 75666 | 29 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82390

82390

Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 5.00

Required Qty: 5.00

D3393-1

Manufactured No

100

Each

16.0000

1

5

D3393-1

Battery Lock Casing

**

⑤ FF 12-04-27

Location

Loc Qty

Loc Code

st493

16

79171

16

5

D3393-3

Manufactured No

140

Each

5.0000

1

5

D3393-3

Cam Lock Shaft

**

⑤ FF 12-04-27

Location

Loc Qty

Loc Code

ST041

5

77090

5

5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



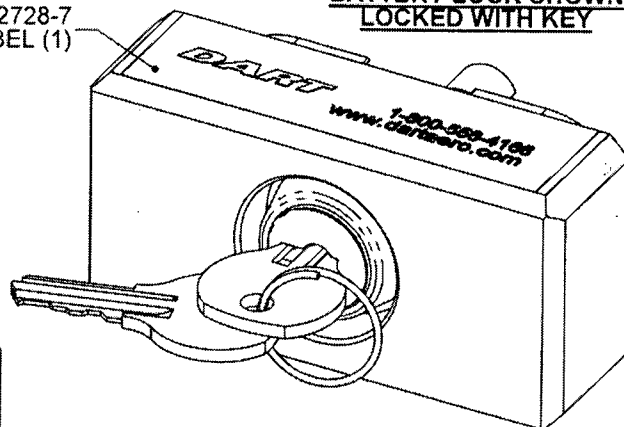
| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3393 | REV. A SHEET 1 OF 3 |
| DATE 05.02.08 | | TITLE BATTERY LOCK | SCALE 1:1 |
| A | 05.02.08 | NEW ISSUE | |

RELEASED
[Signature]

05/03/09

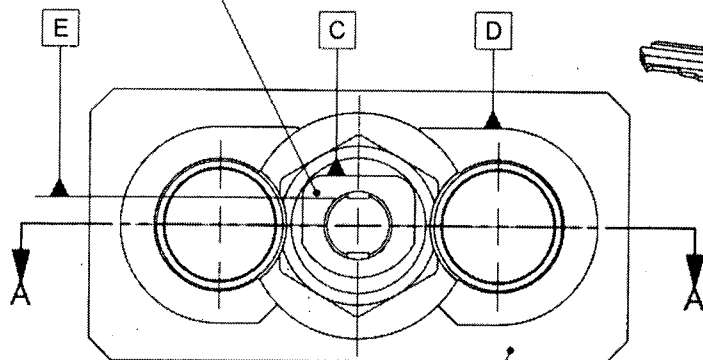
D2728-7
LABEL (1)

**BATTERY LOCK SHOWN
LOCKED WITH KEY**



POSITION FACE **C** OF D3369-5

PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUE

D3393-3 CAM
LOCK SHAFT (1)

$0.09^{+0.03}_{-0.01}$ (2 PLACES)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

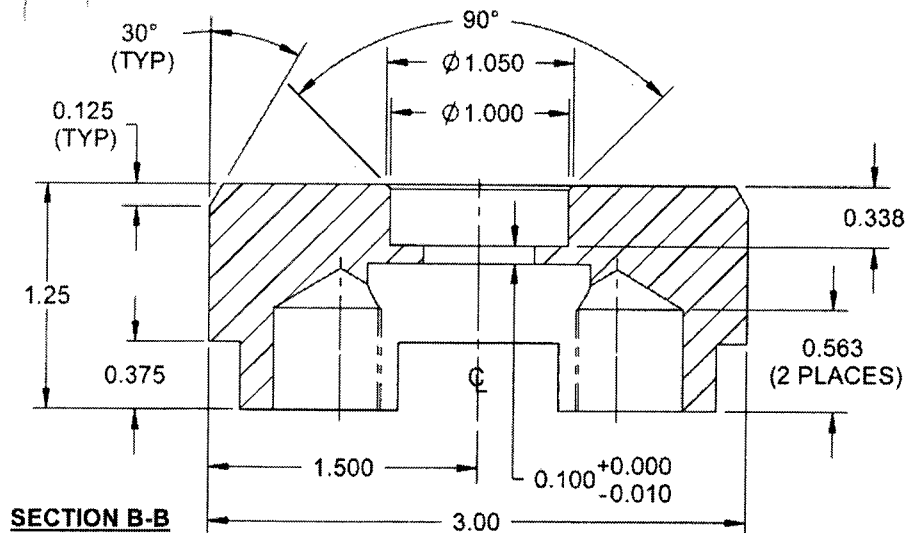
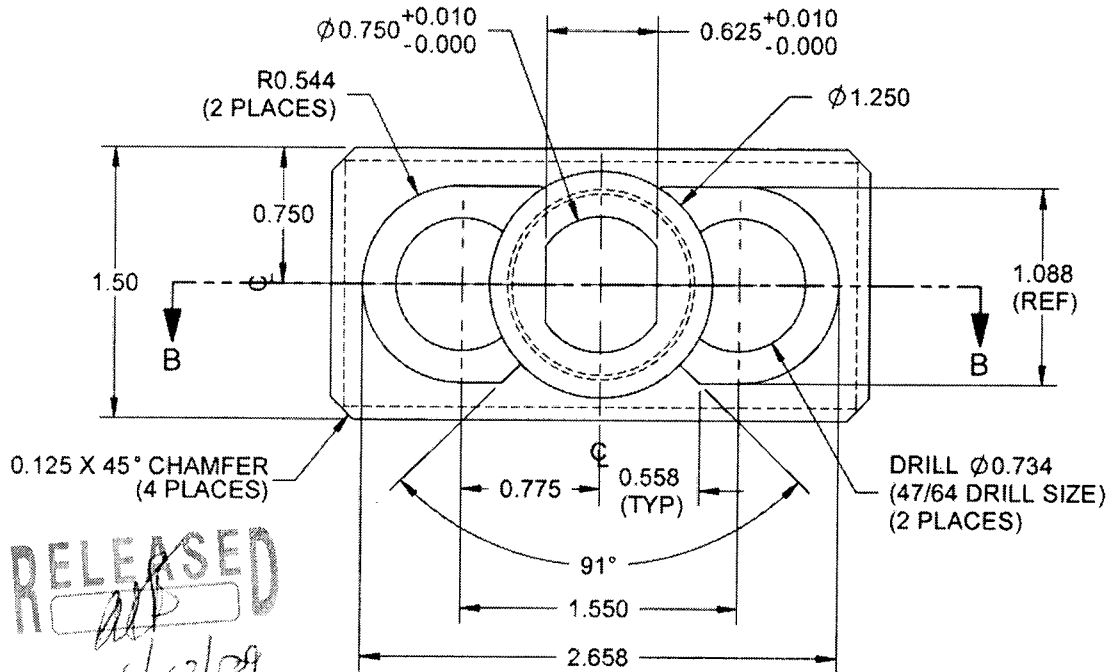
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WITHOUT NOTICE
WORK ORDER
NO. 82390 MCLJ
12/03/30



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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3393 | REV. A |
| DATE 05.02.09 | | TITLE BATTERY LOCK | SHEET 2 OF 3 SCALE 1:1 |



D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

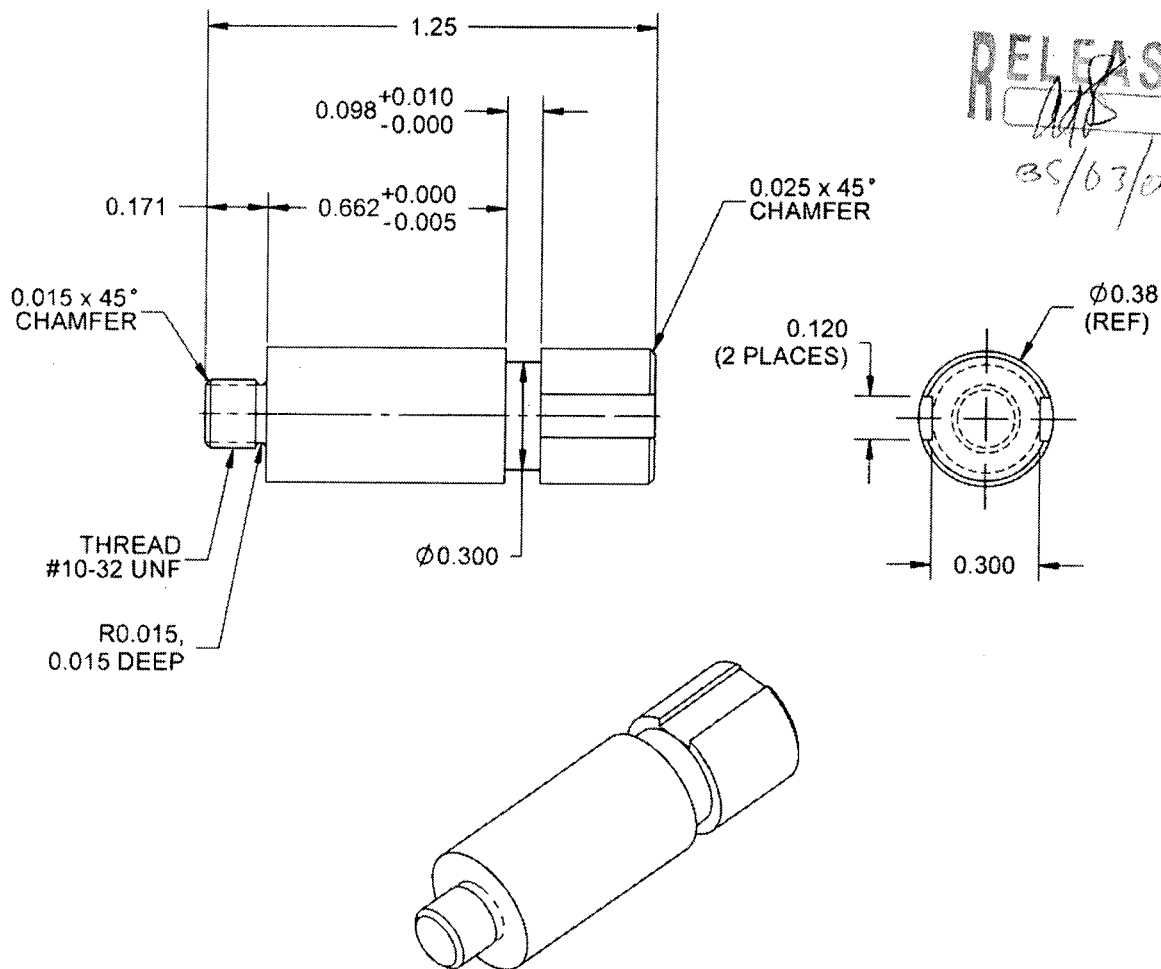
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3393 | REV. A SHEET 3 OF 3 |
| DATE 05.02.09 | | TITLE BATTERY LOCK | SCALE 2:1 |



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

02390

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